

# Work Order ID 55605

January 25, 2010 12:43:40 PM



Page 1

Item ID: D3500-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle

Start Date: 1/25/10

Start Qty: 30.00



Cust Item ID:

Required Date: 2/01/10

Req'd Qty: 30.00



Customer:

Reference:

Run Start



Approvals: Process Plan: *PL*

Date: *10-1-25*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Draw<br>Number | Draw<br>Rev. | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr

Revision Nbr

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Program Batch No. *55605* Double check by: *mm* ☐ 1-Machine Step No 1 per Folio FA641 and inspect per attached Dimension Sheets ☐ 2-Machine Step No 2 per Folio FA641 and inspect per attached Dimension Sheets ☐ 3-Machine Step No 3 per Folio FA641 and inspect p

*mm* *10/02/01* *10/02/02*

*30*

*0*

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

*mm* *10/02/01* *10/02/02*

*30*

*0*

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

*BP* *10/02/08*

*30*

*0*

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

**Work Order ID 55605**

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Page 2

Item ID: D3500-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Saddle

Start Date: 1/25/10 Start Qty: 30.00

Required Date: 2/01/10 Req'd Qty: 30.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

0.00

Memo

BA 10-02-6

(30)

φ

140



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

0.00

Memo

START TIME: 11:45pm OVEN TEMPERATURE:  
12:15pm FINISH TIME: 320°F

27 HU 10/02/8

(X30)

φ

150



QC

Quality Control

QC3- Inspect Part Finish

0.00

0.00

Memo

BR 10-02-8

(30)

φ

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

**Work Order ID 55605**

January 25, 2010 12:43:40 PM



Page 3

Item ID: D3500-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle

Start Date: 1/25/10 Start Qty: 30.00



Cust Item ID:

Required Date: 2/01/10 Req'd Qty: 30.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00



Packaging

Memo

0.00

Packaging

1/25/11 (30)

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/02/11

W 10.02.11

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

January 25, 2010 12:43:45 PM

Page 1

Work Order ID: 55605



Parent Item: D3500-1



Parent Item Name: Saddle

Start Date: 1/25/10

Required Date: 2/01/10

Comments: IPP Rev:A New Issue 06-06-15 JLM

Start Qty: 30.00

Required Qty: 30.00

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Remaining<br>Qty To Pick | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| D6102-013                       |                        | Manufactured  | No          |                     |                  | 100             | Each               | 31.0000        | 30.0000                  |               |                |        |



Saddle Billet

| <u>Warehouse</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|------------------|----------------|-----------------|
| <u>Location</u>  |                |                 |
| Main Warehouse   |                |                 |
| MAT              | 31             |                 |
| 41962            | 1              |                 |
| 46414            | 30             |                 |

30  
10/02/02  
DJP

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



|                              |  |                     |                    |
|------------------------------|--|---------------------|--------------------|
| <b>DART AEROSPACE LTD</b>    |  | <b>Work Order:</b>  | 55605              |
| <b>Description:</b> Saddle   |  | <b>Part Number:</b> | D3500-1            |
| <b>Inspection Dwg:</b> D3500 |  | <b>Rev:</b> C       | <b>Page 1 of 1</b> |

|               |        |        |                | Recorded Actual Dimensions |       |        |       |    |      |
|---------------|--------|--------|----------------|----------------------------|-------|--------|-------|----|------|
| Dim           | Min    | Max    | Go/No Go Gauge | 1                          | 2     | 3      | 4     | By | Date |
| A             | 0.483  | 0.490  |                | .486                       | .486  | 0.487  | 0.487 |    |      |
| B             | 1.175  | 1.185  |                | 1.178                      | 1.176 | 1.178  | 1.178 |    |      |
| C             | 3.145  | 3.155  |                | 3.149                      | 3.150 | 3.149  | 3.150 |    |      |
| D             | 1.175  | 1.185  |                | 1.178                      | 1.176 | 1.176  | 1.177 |    |      |
| E             | 0.365  | 0.385  |                | .382                       | .382  | 0.380  | 0.378 |    |      |
| F             | 0.490  | 0.510  |                | .496                       | .498  | 0.499  | 0.498 |    |      |
| H             |        |        |                |                            |       |        |       |    |      |
| I             | R1.575 | R1.595 |                | 1.590                      | 1.591 | 1.5795 | 1.578 |    |      |
| J             | 0.240  | 0.260  |                | .243                       | .246  | 0.244  | 0.243 |    |      |
| K             | 0.490  | 0.510  |                | .497                       | .498  | 0.498  | 0.498 |    |      |
| L             | 3.590  | 3.650  |                | 3.616                      | 3.613 | 3.624  | 3.620 |    |      |
| M             | 0.315  | 0.322  |                | .317                       | .317  | 0.317  | 0.317 |    |      |
| N             | 0.256  | 0.262  |                | .260                       | .260  | 0.260  | 0.260 |    |      |
| O             | 6.500  | 6.520  |                | 6.510                      | 6.511 | 6.512  | 6.512 |    |      |
| P             | 5.990  | 6.010  |                | 5.999                      | 6.000 | 6.002  | 6.002 |    |      |
| Q             | 2.820  | 2.830  |                | 2.825                      | 2.823 | 2.825  | 2.825 |    |      |
| R             | 2.495  | 2.505  |                | 2.496                      | 2.497 | 2.500  | 2.500 |    |      |
| S             | 2.245  | 2.255  |                | 2.250                      | 2.250 | 2.250  | 2.250 |    |      |
| T             | 1.120  | 1.130  |                | 1.124                      | 1.125 | 1.125  | 1.125 |    |      |
| U             | 0.540  | 0.560  |                | .542                       | .542  | 0.542  | 0.544 |    |      |
| V             | 0.793  | 0.803  |                | .797                       | .799  | 0.798  | 0.798 |    |      |
| W             | R.240  | R.260  |                | R.250                      | R.250 | 0.250  | .250  |    |      |
| X             | 0.040  | 0.060  |                | .050                       | .050  | 0.050  | 0.050 |    |      |
| Y             | 0.100  | 0.120  |                | .105                       | .110  | 0.108  | 0.110 |    |      |
| AA            | R1.125 | R1.145 |                | 1.135                      | 1.137 | 1.134  | 1.131 |    |      |
| AB            | R.490  | R.510  |                | R.500                      | R.500 | 0.500  | 0.500 |    |      |
| AC            | 0.615  | 0.635  |                | .625                       | .630  | 0.635  | 0.635 |    |      |
| AD            | 0.240  | 0.260  |                | .253                       | .253  | 0.255  | 0.252 |    |      |
| AE            | 1.810  | 1.830  |                | 1.821                      | 1.820 | 1.816  | 1.816 |    |      |
| AF            | 0.240  | 0.260  |                | .248                       | .248  | 0.246  | 0.246 |    |      |
| AG            | 0.140  | 0.160  |                | .150                       | .149  | 0.145  | 0.145 |    |      |
| AH            | 0.140  | 0.160  |                | .151                       | .151  | 0.150  | 0.150 |    |      |
| AI            | 0.140  | 0.160  |                | .152                       | .153  | 0.160  | 0.151 |    |      |
| Accept/Reject |        |        |                |                            |       |        |       |    |      |

Measured by: MMJ  
Date: 10/02/01 / 10/02/02

Audited by: BF  
Date: 10/02/08

| Rev | Date     | Change                | Revised by | Approved |
|-----|----------|-----------------------|------------|----------|
| A   | 06.09.26 | New Issue             | KJ/EC      |          |
| B   | 08.10.07 | Dimension H removed   | KJ/DD      |          |
| C   | 08.11.28 | Dimension 'M' revised | KJ/EC      |          |

|                              |  |                     |                    |
|------------------------------|--|---------------------|--------------------|
| <b>DART AEROSPACE LTD</b>    |  | <b>Work Order:</b>  | 55405              |
| <b>Description: Saddle</b>   |  | <b>Part Number:</b> | D3500-1            |
| <b>Inspection Dwg: D3500</b> |  | <b>Rev: C</b>       | <b>Page 1 of 1</b> |

| Dim           | Min    | Max    | Go/No<br>Go<br>Gauge | Recorded Actual Dimensions |       |        |        | By | Date |
|---------------|--------|--------|----------------------|----------------------------|-------|--------|--------|----|------|
|               |        |        |                      | 5                          | 6     | 7      | 8      |    |      |
| A             | 0.483  | 0.490  |                      | 0.487                      | 0.487 | 0.487  | .487   |    |      |
| B             | 1.175  | 1.185  |                      | 1.179                      | 1.179 | 1.179  | 1.179  |    |      |
| C             | 3.145  | 3.155  |                      | 3.150                      | 3.150 | 3.150  | 3.150  |    |      |
| D             | 1.175  | 1.185  |                      | 1.179                      | 1.179 | 1.179  | 1.179  |    |      |
| E             | 0.365  | 0.385  |                      | 0.379                      | 0.378 | 0.380  | 0.377  |    |      |
| F             | 0.490  | 0.510  |                      | 0.495                      | 0.496 | 0.4955 | 0.495  |    |      |
| H             |        |        |                      |                            |       |        |        |    |      |
| I             | R1.575 | R1.595 |                      | 1.5785                     | 1.584 | 1.5805 | 1.5815 |    |      |
| J             | 0.240  | 0.260  |                      | 0.242                      | 0.242 | 0.242  | 0.242  |    |      |
| K             | 0.490  | 0.510  |                      | 0.498                      | 0.500 | 0.4995 | 0.499  |    |      |
| L             | 3.590  | 3.650  |                      | 3.624                      | 3.620 | 3.617  | 3.615  |    |      |
| M             | 0.315  | 0.322  |                      | 0.317                      | 0.317 | 0.317  | .317   |    |      |
| N             | 0.256  | 0.262  |                      | 0.259                      | 0.259 | 0.259  | .259   |    |      |
| O             | 6.500  | 6.520  |                      | 6.512                      | 6.512 | 6.512  | 6.512  |    |      |
| P             | 5.990  | 6.010  |                      | 6.002                      | 6.002 | 6.002  | 6.002  |    |      |
| Q             | 2.820  | 2.830  |                      | 2.825                      | 2.825 | 2.825  | 2.825  |    |      |
| R             | 2.495  | 2.505  |                      | 2.500                      | 2.500 | 2.500  | 2.500  |    |      |
| S             | 2.245  | 2.255  |                      | 2.250                      | 2.250 | 2.250  | 2.250  |    |      |
| T             | 1.120  | 1.130  |                      | 1.125                      | 1.125 | 1.125  | 1.125  |    |      |
| U             | 0.540  | 0.560  |                      | 0.545                      | 0.543 | 0.547  | 0.546  |    |      |
| V             | 0.793  | 0.803  |                      | 0.798                      | 0.798 | 0.798  | 0.798  |    |      |
| W             | R.240  | R.260  |                      | .250                       | .250  | .250   | .250   |    |      |
| X             | 0.040  | 0.060  |                      | .050                       | 0.050 | 0.050  | 0.050  |    |      |
| Y             | 0.100  | 0.120  |                      | 0.105                      | 0.110 | 0.110  | 0.110  |    |      |
| AA            | R1.125 | R1.145 |                      | 1.134                      | 1.140 | 1.1365 | 1.1355 |    |      |
| AB            | R.490  | R.510  |                      | .500                       | .500  | .500   | .500   |    |      |
| AC            | 0.615  | 0.635  |                      | 0.635                      | 0.635 | 0.635  | 0.635  |    |      |
| AD            | 0.240  | 0.260  |                      | 0.252                      | 0.252 | 0.252  | 0.251  |    |      |
| AE            | 1.810  | 1.830  |                      | 1.819                      | 1.823 | 1.821  | 1.818  |    |      |
| AF            | 0.240  | 0.260  |                      | 0.248                      | 0.252 | 0.2505 | 0.249  |    |      |
| AG            | 0.140  | 0.160  |                      | 0.149                      | 0.153 | 0.152  | 0.150  |    |      |
| AH            | 0.140  | 0.160  |                      | 0.148                      | 0.148 | 0.145  | 0.145  |    |      |
| AI            | 0.140  | 0.160  |                      | 0.150                      | 0.148 | 0.145  | 0.147  |    |      |
| Accept/Reject |        |        |                      |                            |       |        |        |    |      |

|              |          |
|--------------|----------|
| Measured by: | DJP      |
| Date:        | 10/02/02 |

|             |          |
|-------------|----------|
| Audited by: | JS       |
| Date:       | 10/02/02 |

| Rev | Date     | Change                | Revised by | Approved |
|-----|----------|-----------------------|------------|----------|
| A   | 06.09.26 | New Issue             | KJ/EC      |          |
| B   | 08.10.07 | Dimension H removed   | KJ/DD      |          |
| C   | 08.11.28 | Dimension 'M' revised | KJ/EC      |          |

|                              |  |                     |                    |
|------------------------------|--|---------------------|--------------------|
| <b>DART AEROSPACE LTD</b>    |  | <b>Work Order:</b>  | 55605              |
| <b>Description: Saddle</b>   |  | <b>Part Number:</b> | D3500-1            |
| <b>Inspection Dwg: D3500</b> |  | <b>Rev: C</b>       | <b>Page 1 of 1</b> |

|               |        |        |                | Recorded Actual Dimensions |        |       |        | By | Date |
|---------------|--------|--------|----------------|----------------------------|--------|-------|--------|----|------|
| Dim           | Min    | Max    | Go/No Go Gauge | 9                          | 10     | 11    | 12     |    |      |
| A             | 0.483  | 0.490  |                | .487                       | 0.487  | 0.487 | 0.487  |    |      |
| B             | 1.175  | 1.185  |                | 1.179                      | 1.179  | 1.179 | 1.179  |    |      |
| C             | 3.145  | 3.155  |                | 3.150                      | 3.150  | 3.150 | 3.150  |    |      |
| D             | 1.175  | 1.185  |                | 1.179                      | 1.179  | 1.179 | 1.179  |    |      |
| E             | 0.365  | 0.385  |                | 0.380                      | 0.380  | 0.380 | 0.380  |    |      |
| F             | 0.490  | 0.510  |                | 0.495                      | 0.495  | 0.496 | 0.496  |    |      |
| H             |        |        |                |                            |        |       |        |    |      |
| I             | R1.575 | R1.595 |                | 1.580                      | 1.579  | 1.580 | 1.580  |    |      |
| J             | 0.240  | 0.260  |                | 0.242                      | 0.242  | 0.242 | 0.243  |    |      |
| K             | 0.490  | 0.510  |                | 0.499                      | 0.498  | 0.498 | 0.499  |    |      |
| L             | 3.590  | 3.650  |                | 3.620                      | 3.620  | 3.620 | 3.62   |    |      |
| M             | 0.315  | 0.322  |                | .317                       | .317   | .317  | .317   |    |      |
| N             | 0.256  | 0.262  |                | .259                       | .259   | .259  | .259   |    |      |
| O             | 6.500  | 6.520  |                | 6.510                      | 6.511  | 6.512 | 6.512  |    |      |
| P             | 5.990  | 6.010  |                | 6.000                      | 6.001  | 6.002 | 6.002  |    |      |
| Q             | 2.820  | 2.830  |                | 2.825                      | 2.825  | 2.825 | 2.825  |    |      |
| R             | 2.495  | 2.505  |                | 2.500                      | 2.500  | 2.500 | 2.500  |    |      |
| S             | 2.245  | 2.255  |                | 2.250                      | 2.250  | 2.250 | 2.250  |    |      |
| T             | 1.120  | 1.130  |                | 1.125                      | 1.125  | 1.125 | 1.125  |    |      |
| U             | 0.540  | 0.560  |                | 0.548                      | 0.547  | 0.547 | 0.547  |    |      |
| V             | 0.793  | 0.803  |                | 0.798                      | .798   | .798  | .798   |    |      |
| W             | R.240  | R.260  |                | 0.250                      | .250   | .250  | .250   |    |      |
| X             | 0.040  | 0.060  |                | 0.050                      | 0.050  | 0.050 | 0.050  |    |      |
| Y             | 0.100  | 0.120  |                | 0.110                      | 0.110  | 0.110 | 0.110  |    |      |
| AA            | R1.125 | R1.145 |                | 1.135                      | 1.137  | 1.137 | 1.137  |    |      |
| AB            | R.490  | R.510  |                | 0.500                      | .500   | .500  | .500   |    |      |
| AC            | 0.615  | 0.635  |                | 0.635                      | .635   | .635  | .635   |    |      |
| AD            | 0.240  | 0.260  |                | 0.251                      | 0.253  | 0.252 | 0.253  |    |      |
| AE            | 1.810  | 1.830  |                | 1.821                      | 1.8215 | 1.820 | 1.8215 |    |      |
| AF            | 0.240  | 0.260  |                | 0.250                      | 0.250  | 0.250 | 0.250  |    |      |
| AG            | 0.140  | 0.160  |                | 0.151                      | 0.151  | 0.151 | 0.151  |    |      |
| AH            | 0.140  | 0.160  |                | 0.151                      | 0.148  | 0.150 | 0.150  |    |      |
| AI            | 0.140  | 0.160  |                | 0.148                      | 0.152  | 0.152 | 0.154  |    |      |
| Accept/Reject |        |        |                |                            |        |       |        |    |      |

|              |          |
|--------------|----------|
| Measured by: | SDP      |
| Date:        | 10/02/02 |

|             |          |
|-------------|----------|
| Audited by: | JP       |
| Date:       | 10/02/02 |

| Rev | Date     | Change                | Revised by | Approved |
|-----|----------|-----------------------|------------|----------|
| A   | 06.09.26 | New Issue             | KJ/EC      |          |
| B   | 08.10.07 | Dimension H removed   | KJ/DD      |          |
| C   | 08.11.28 | Dimension 'M' revised | KJ/EC      | JP       |

|                              |               |                     |         |
|------------------------------|---------------|---------------------|---------|
| <b>DART AEROSPACE LTD</b>    |               | <b>Work Order:</b>  | 55605   |
| <b>Description: Saddle</b>   |               | <b>Part Number:</b> | D3500-1 |
| <b>Inspection Dwg: D3500</b> | <b>Rev: C</b> | <b>Page 1 of 1</b>  |         |

| Dim           | Min    | Max    | Go/No<br>Go<br>Gauge | Recorded Actual Dimensions |       |       |        | By | Date |
|---------------|--------|--------|----------------------|----------------------------|-------|-------|--------|----|------|
|               |        |        |                      | 13                         | 14    | 15    | 16     |    |      |
| A             | 0.483  | 0.490  |                      | 0.487                      | 0.487 | 0.487 | 0.487  |    |      |
| B             | 1.175  | 1.185  |                      | 1.179                      | 1.179 | 1.179 | 1.179  |    |      |
| C             | 3.145  | 3.155  |                      | 3.150                      | 3.150 | 3.150 | 3.150  |    |      |
| D             | 1.175  | 1.185  |                      | 1.179                      | 1.179 | 1.179 | 1.179  |    |      |
| E             | 0.365  | 0.385  |                      | 0.380                      | 0.380 | 0.380 | 0.380  |    |      |
| F             | 0.490  | 0.510  |                      | 0.498                      | 0.496 | 0.496 | 0.496  |    |      |
| H             |        |        |                      |                            |       |       |        |    |      |
| I             | R1.575 | R1.595 |                      | 1.580                      | 1.581 | 1.585 | 1.5785 |    |      |
| J             | 0.240  | 0.260  |                      | 0.243                      | 0.243 | 0.243 | 0.243  |    |      |
| K             | 0.490  | 0.510  |                      | 0.499                      | 0.499 | 0.499 | 0.499  |    |      |
| L             | 3.590  | 3.650  |                      | 3.620                      | 3.620 | 3.620 | 3.620  |    |      |
| M             | 0.315  | 0.322  |                      | 0.317                      | 0.317 | 0.317 | 0.317  |    |      |
| N             | 0.256  | 0.262  |                      | 0.259                      | 0.259 | 0.259 | 0.259  |    |      |
| O             | 6.500  | 6.520  |                      | 6.510                      | 6.511 | 6.511 | 6.511  |    |      |
| P             | 5.990  | 6.010  |                      | 6.000                      | 6.001 | 6.001 | 6.001  |    |      |
| Q             | 2.820  | 2.830  |                      | 2.825                      | 2.825 | 2.825 | 2.825  |    |      |
| R             | 2.495  | 2.505  |                      | 2.500                      | 2.500 | 2.500 | 2.500  |    |      |
| S             | 2.245  | 2.255  |                      | 2.250                      | 2.250 | 2.250 | 2.250  |    |      |
| T             | 1.120  | 1.130  |                      | 1.125                      | 1.125 | 1.125 | 1.125  |    |      |
| U             | 0.540  | 0.560  |                      | 0.547                      | 0.547 | 0.547 | 0.547  |    |      |
| V             | 0.793  | 0.803  |                      | 0.798                      | 0.798 | 0.798 | 0.798  |    |      |
| W             | R.240  | R.260  |                      | 0.250                      | 0.250 | 0.250 | 0.250  |    |      |
| X             | 0.040  | 0.060  |                      | 0.050                      | 0.050 | 0.050 | 0.050  |    |      |
| Y             | 0.100  | 0.120  |                      | 0.110                      | 0.110 | 0.110 | 0.110  |    |      |
| AA            | R1.125 | R1.145 |                      | 1.1355                     | 1.136 | 1.140 | 1.137  |    |      |
| AB            | R.490  | R.510  |                      | 0.500                      | 0.500 | 0.500 | 0.500  |    |      |
| AC            | 0.615  | 0.635  |                      | 0.635                      | 0.635 | 0.635 | 0.635  |    |      |
| AD            | 0.240  | 0.260  |                      | 0.254                      | 0.253 | 0.252 | 0.252  |    |      |
| AE            | 1.810  | 1.830  |                      | 1.8215                     | 1.821 | 1.822 | 1.820  |    |      |
| AF            | 0.240  | 0.260  |                      | 0.250                      | 0.250 | 0.251 | 0.249  |    |      |
| AG            | 0.140  | 0.160  |                      | 0.151                      | 0.151 | 0.152 | 0.150  |    |      |
| AH            | 0.140  | 0.160  |                      | 0.150                      | 0.150 | 0.148 | 0.150  |    |      |
| AI            | 0.140  | 0.160  |                      | 0.153                      | 0.153 | 0.153 | 0.153  |    |      |
| Accept/Reject |        |        |                      |                            |       |       |        |    |      |

|              |          |
|--------------|----------|
| Measured by: | DTT      |
| Date:        | 10/02/02 |

|             |          |
|-------------|----------|
| Audited by: | AB       |
| Date:       | 10/02/08 |

| Rev | Date     | Change                | Revised by | Approved |
|-----|----------|-----------------------|------------|----------|
| A   | 06.09.26 | New Issue             | KJ/EC      |          |
| B   | 08.10.07 | Dimension H removed   | KJ/DD      |          |
| C   | 08.11.28 | Dimension 'M' revised | KJ/EC      |          |

|                              |               |                     |         |
|------------------------------|---------------|---------------------|---------|
| <b>DART AEROSPACE LTD</b>    |               | <b>Work Order:</b>  | 55605   |
| <b>Description: Saddle</b>   |               | <b>Part Number:</b> | D3500-1 |
| <b>Inspection Dwg: D3500</b> | <b>Rev: C</b> | <b>Page 1 of 1</b>  |         |

| Dim           | Min    | Max    | Go/No<br>Go<br>Gauge | Recorded Actual Dimensions |        |       |       | By | Date |
|---------------|--------|--------|----------------------|----------------------------|--------|-------|-------|----|------|
|               |        |        |                      | 17                         | 18     | 19    | 20    |    |      |
| A             | 0.483  | 0.490  |                      | 0.487                      | .487   | 0.487 | 0.487 |    |      |
| B             | 1.175  | 1.185  |                      | 1.179                      | 1.179  | 1.179 | 1.179 |    |      |
| C             | 3.145  | 3.155  |                      | 3.150                      | 3.150  | 3.150 | 3.150 |    |      |
| D             | 1.175  | 1.185  |                      | 1.179                      | 1.179  | 1.179 | 1.179 |    |      |
| E             | 0.365  | 0.385  |                      | 0.380                      | 0.377  | 0.377 | 0.380 |    |      |
| F             | 0.490  | 0.510  |                      | 0.498                      | 0.496  | 0.497 | 0.496 |    |      |
| H             |        |        |                      |                            |        |       |       |    |      |
| I             | R1.575 | R1.595 |                      | 1.5805                     | 1.585  | 1.583 | 1.580 |    |      |
| J             | 0.240  | 0.260  |                      | 0.242                      | 0.243  | 0.243 | 0.243 |    |      |
| K             | 0.490  | 0.510  |                      | 0.499                      | 0.499  | 0.499 | 0.499 |    |      |
| L             | 3.590  | 3.650  |                      | 3.620                      | 3.62   | 3.622 | 3.625 |    |      |
| M             | 0.315  | 0.322  |                      | 0.317                      | 0.317  | 0.317 | 0.317 |    |      |
| N             | 0.256  | 0.262  |                      | 0.259                      | .259   | 0.259 | 0.259 |    |      |
| O             | 6.500  | 6.520  |                      | 6.511                      | 6.511  | 6.512 | 6.512 |    |      |
| P             | 5.990  | 6.010  |                      | 6.001                      | 6.001  | 6.002 | 6.002 |    |      |
| Q             | 2.820  | 2.830  |                      | 2.825                      | 2.825  | 2.825 | 2.825 |    |      |
| R             | 2.495  | 2.505  |                      | 2.500                      | 2.500  | 2.500 | 2.500 |    |      |
| S             | 2.245  | 2.255  |                      | 2.250                      | 2.250  | 2.250 | 2.250 |    |      |
| T             | 1.120  | 1.130  |                      | 1.125                      | 1.125  | 1.125 | 1.125 |    |      |
| U             | 0.540  | 0.560  |                      | 0.546                      | 0.546  | 0.546 | 0.546 |    |      |
| V             | 0.793  | 0.803  |                      | 0.798                      | 0.798  | .798  | .798  |    |      |
| W             | R.240  | R.260  |                      | 0.250                      | 0.250  | .250  | .250  |    |      |
| X             | 0.040  | 0.060  |                      | 0.050                      | 0.050  | 0.050 | 0.050 |    |      |
| Y             | 0.100  | 0.120  |                      | 0.110                      | 0.110  | 0.110 | 0.110 |    |      |
| AA            | R1.125 | R1.145 |                      | 1.135                      | 1.1385 | 1.136 | 1.136 |    |      |
| AB            | R.490  | R.510  |                      | 0.500                      | 0.500  | .500  | .500  |    |      |
| AC            | 0.615  | 0.635  |                      | 0.635                      | 0.635  | .635  | .635  |    |      |
| AD            | 0.240  | 0.260  |                      | 0.252                      | 0.251  | 0.251 | 0.251 |    |      |
| AE            | 1.810  | 1.830  |                      | 1.820                      | 1.823  | 1.820 | 1.820 |    |      |
| AF            | 0.240  | 0.260  |                      | 0.249                      | 0.252  | 0.249 | 0.249 |    |      |
| AG            | 0.140  | 0.160  |                      | 0.149                      | 0.153  | 0.150 | 0.150 |    |      |
| AH            | 0.140  | 0.160  |                      | 0.148                      | 0.148  | 0.148 | 0.147 |    |      |
| AI            | 0.140  | 0.160  |                      | 0.150                      | 0.150  | 0.149 | 0.152 |    |      |
| Accept/Reject |        |        |                      |                            |        |       |       |    |      |

Measured by: DJP  
Date: 10/02/03

Audited by: SP  
Date: 10/02/04

| Rev | Date     | Change                | Revised by | Approved |
|-----|----------|-----------------------|------------|----------|
| A   | 06.09.26 | New Issue             | KJ/EC      |          |
| B   | 08.10.07 | Dimension H removed   | KJ/DD      |          |
| C   | 08.11.28 | Dimension 'M' revised | KJ/EC      |          |



|                              |               |                     |         |
|------------------------------|---------------|---------------------|---------|
| <b>DART AEROSPACE LTD</b>    |               | <b>Work Order:</b>  | 55605   |
| <b>Description: Saddle</b>   |               | <b>Part Number:</b> | D3500-1 |
| <b>Inspection Dwg: D3500</b> | <b>Rev: C</b> | <b>Page 1 of 1</b>  |         |

|               |        |        |                | Recorded Actual Dimensions |       |        |        |    |      |
|---------------|--------|--------|----------------|----------------------------|-------|--------|--------|----|------|
| Dim           | Min    | Max    | Go/No Go Gauge | 25                         | 26    | 27     | 28     | By | Date |
| A             | 0.483  | 0.490  |                | 0.487                      | 0.487 | 0.487  | 0.487  |    |      |
| B             | 1.175  | 1.185  |                | 1.179                      | 1.179 | 1.179  | 1.179  |    |      |
| C             | 3.145  | 3.155  |                | 3.150                      | 3.150 | 3.150  | 3.150  |    |      |
| D             | 1.175  | 1.185  |                | 1.179                      | 1.179 | 1.179  | 1.179  |    |      |
| E             | 0.365  | 0.385  |                | 0.380                      | 0.380 | 0.380  | 0.380  |    |      |
| F             | 0.490  | 0.510  |                | 0.496                      | 0.496 | 0.498  | 0.498  |    |      |
| H             |        |        |                |                            |       |        |        |    |      |
| I             | R1.575 | R1.595 |                | 1.586                      | 1.582 | 1.5805 | 1.582  |    |      |
| J             | 0.240  | 0.260  |                | 0.242                      | 0.241 | 0.2415 | 0.241  |    |      |
| K             | 0.490  | 0.510  |                | 0.499                      | 0.499 | 0.499  | 0.499  |    |      |
| L             | 3.590  | 3.650  |                | 3.625                      | 3.625 | 3.625  | 3.625  |    |      |
| M             | 0.315  | 0.322  |                | 0.317                      | 0.317 | 0.317  | 0.317  |    |      |
| N             | 0.256  | 0.262  |                | 0.259                      | 0.259 | 0.259  | 0.259  |    |      |
| O             | 6.500  | 6.520  |                | 6.510                      | 6.510 | 6.511  | 6.511  |    |      |
| P             | 5.990  | 6.010  |                | 6.000                      | 6.000 | 6.001  | 6.001  |    |      |
| Q             | 2.820  | 2.830  |                | 2.825                      | 2.825 | 2.825  | 2.825  |    |      |
| R             | 2.495  | 2.505  |                | 2.500                      | 2.500 | 2.500  | 2.500  |    |      |
| S             | 2.245  | 2.255  |                | 2.250                      | 2.250 | 2.250  | 2.250  |    |      |
| T             | 1.120  | 1.130  |                | 1.125                      | 1.125 | 1.125  | 1.125  |    |      |
| U             | 0.540  | 0.560  |                | 0.547                      | 0.547 | 0.547  | 0.547  |    |      |
| V             | 0.793  | 0.803  |                | 0.798                      | 0.798 | 0.798  | 0.798  |    |      |
| W             | R.240  | R.260  |                | 0.250                      | 0.250 | 0.250  | 0.250  |    |      |
| X             | 0.040  | 0.060  |                | 0.050                      | 0.050 | 0.050  | 0.050  |    |      |
| Y             | 0.100  | 0.120  |                | 0.110                      | 0.110 | 0.110  | 0.110  |    |      |
| AA            | R1.125 | R1.145 |                | 1.137                      | 1.135 | 1.134  | 1.135  |    |      |
| AB            | R.490  | R.510  |                | 0.500                      | 0.500 | 0.500  | 0.500  |    |      |
| AC            | 0.615  | 0.635  |                | 0.635                      | 0.635 | 0.635  | 0.635  |    |      |
| AD            | 0.240  | 0.260  |                | 0.251                      | 0.251 | 0.251  | 0.251  |    |      |
| AE            | 1.810  | 1.830  |                | 1.823                      | 1.819 | 1.819  | 1.8195 |    |      |
| AF            | 0.240  | 0.260  |                | 0.250                      | 0.249 | 0.248  | 0.248  |    |      |
| AG            | 0.140  | 0.160  |                | 0.153                      | 0.149 | 0.149  | 0.149  |    |      |
| AH            | 0.140  | 0.160  |                | 0.148                      | 0.150 | 0.150  | 0.150  |    |      |
| AI            | 0.140  | 0.160  |                | 0.150                      | 0.152 | 0.152  | 0.151  |    |      |
| Accept/Reject |        |        |                |                            |       |        |        |    |      |

|                         |                       |
|-------------------------|-----------------------|
| Measured by: <i>DTD</i> | Audited by: <i>SP</i> |
| Date: 10/02/06          | Date: 10/02/08        |

| Rev | Date     | Change                | Revised by | Approved   |
|-----|----------|-----------------------|------------|------------|
| A   | 06.09.26 | New Issue             | KJ/EC      |            |
| B   | 08.10.07 | Dimension H removed   | KJ/DD      |            |
| C   | 08.11.28 | Dimension 'M' revised | KJ/EC      | <i>DTD</i> |





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WITHOUT NOTICE  
WORK ORDER

NO. 35605

PH 10-12C

ENGRAVE DART LOGO IN  
THIS AREA TO A MAX  
DEPTH OF 0.015 AND A MIN.  
TOOL RADIUS OF 0.250

0.050x45° CHAMFER  
(TYP)

Ø0.484 (4 PLACES)

**DETAIL B**

R0.525  
(TYP)

R0.260  
(TYP)

**D3500-1 SADDLE**

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/B OR QQ-A-250/11)  
(MAKE FROM D6102-013 SADDLE BILLET, 6061)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1,  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER  
DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

**RELEASED**

06-08-15

|         |          |                                   |
|---------|----------|-----------------------------------|
| C       | 06.06.30 | MAT'L NOW 6061-T6/T651            |
| B       | 06.05.29 | CHANGE DIMS; MAT'L NOW 7075-T7351 |
| A       | 06.04.18 | NEW ISSUE                         |
| DESIGN  | PH       | DRAWN BY PH                       |
| CHECKED | #        | APPROVED #                        |
| DATE    | 06.06.30 | TITLE                             |
|         |          | SADDLE                            |
|         |          | REV. C                            |
|         |          | SHEET 1 OF 1                      |
|         |          | SCALE                             |
|         |          | 2:3                               |

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